

INJECTION MOLDING METHOD FOR PARTIALLY LIGHT PERMEATING PLASTIC MOLDING AND DEVICE THEREFOR

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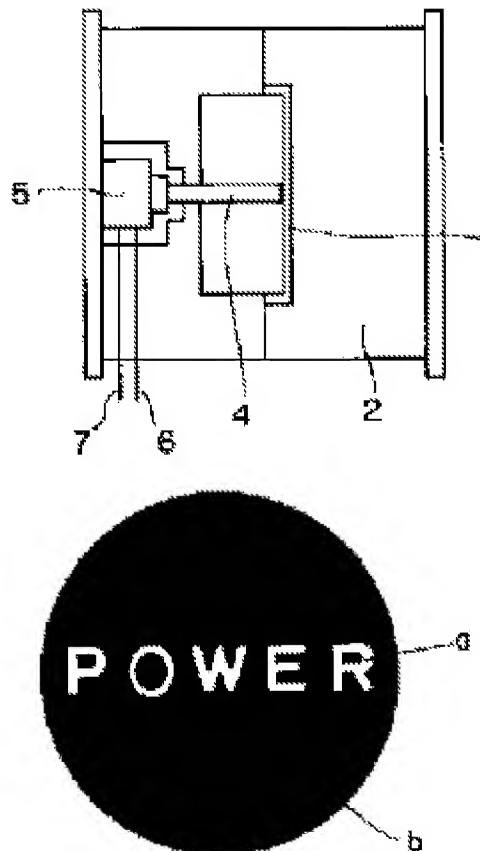
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Abstract of JP9076302

PROBLEM TO BE SOLVED: To reduce the number of parts and operating man-hours and prevent failures by incorporating a movable section which is movable partially to a light permeating section into a main mold at a movable side or a fixed side, advancing the movable section speedily to a predetermined position after it is filled with a resin and cooling it so as to partially form thin parts. **SOLUTION:** At a part corresponding to a light permeating section, a movable section 4 which is movable partially is provided, for example, in a main mold at a movable side. The movable section 4 is filled with a resin and cooled quickly in a state that it is advanced to a predetermined position. Thus, a thin part (a) which permeates light partially is formed. That is, after a cavity 1 between a fixed side main mold 2 and the movable side main mold is filled with the resin, a pressure oil is quickly sent to a pressure oil pushing side 7 of a hydraulic cylinder 5 so as to advance the movable section 4. At the movable section, irregularities of characters are previously provided and the thin part (a) is formed. On the other hand, unnecessary resins among resins at a thick part (b) are removed. Thus, the thin part (a) and the thick part (b) are molded simultaneously, the pressure oil is sent to a pressure oil returning side 6 after it is cooled, so that the movable section backs.



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